USER MANUAL

DOUBLE FACE GLUE SPREADER MASCHINE

Henrik WINTER HOLZTECHNIK GmbH
Druckereistr. 8, 04159 Leipzig-Stahmeln
Holzbearbeitungsmaschinen neu und gebraucht, Werkzeuge, Lüftungs- und Heizungsanlagen
Über 300 Gebrauchtmaschinen am Lager!

Henrik Winter Holztechnik GmbH
Druckereistr. 8
04159 Leipzig

Tel: +49 (0)341/ 4619021 Fax: +49 (0)341/4618358 Funk: +49 (0)171/2820443
Em@il: info@winter-holztechnik.de Internet: www.winter-holztechnik.de

SAFETY RULES

1. Operator should read user manual carefully ,to truly understand the function and operating skills.
2. Reliable earthed device should connect with machine before operation
3. The machine should connect with suitable power ,check if the currency,frequency,voltage are right.
4. Before operation,confirm if the direction of running cutter,saw are all right
5. Checke the safety protecting device are normalor not ,if it is loose or damaged ,replace it in time.
6. Operator should wear tighten clothes in operation ,it is forbidden to wear loose clothes or wear tie ,watch ,necklace ,who have long hair need to wear hats.
7. All safety device can not be removed in running time .
8. Operator are forbidden to leave position when machine is running .
9. It is forbidden to process workpiece which exceed the processing range of machine .
10. Some one drink too much or not in good healthy are forbidden to operate machine.
11. Shut down main power supply before checking ,maintenance cleaning.
12. Shut down main power supply after operation .it is forbidden to leave before machine stop completely.

CATALOGUE

I. User manual ----------1

II. Safety device and protection. ----------1

III. Safety warming and symbol----------2

IV. Main feature and using of the machine----------3

V. Overall and structure of machine ----------3

i. Overall of machine ----------3

ii. Main structure of machine ----------4

VI. Main technology parameter of machine----------8

VII. Loading and transport of machine ----------9

VIII. Install debug and operation of machine ------9

i. Install debug ----------9

ii. Operation ----------10

IX. Failure and solution ----------11

X. Maintenance of machine ----------11

XI. Electrical principle diagram----------13

XII. Electrical fittings detail lists ----------14

XIII. Gluing working principle----------15

XIV. Fitting detail of machine----------16

I. User manual

i. Operation of user manual

Who will operate the machine should be peruse well of the user manual ,and must understand the procedure , safety operation,maintain etc the user manual introduced.and put it close to the machine in order to read convenience .

ii. Copyright of this user manual

This copyright of this user manual is belongs to Tongan company.This instruction is for the buyer and operator using ,the content of it is forbidden to copy,send out and reading by other way .If who disobey this principle ,our company will be run the responsibility

II. Safety device and protection.

i. Before operate the machine should be install the safety protection device correctly ,make sure working under safety condition.

ii. The safety device can be knock down under the condition of power shut down .

iii. You can operate the machine under the all the safety device is working normal .

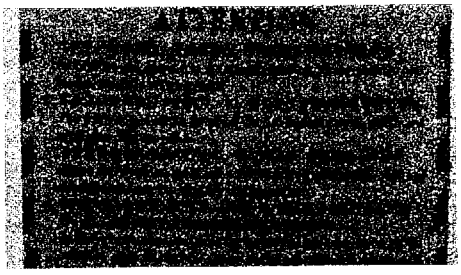
iv. All the procedure transport,install ,debug and maitain should be operate by the professional.

v. Refer to the electrical install and maintain should be in charge by the professional

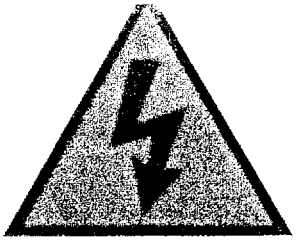
vi. Check the electrical device timing and deal with the loosen or broken electrical fittings in time.Forbidden maintain with electrical .when check and maintain should be shut off the power and keep somebody to see the power make sure the examine and repair person safety .

vii. This machine just only can be used the no volatility ,flammable gluewater .

III. Safety warming and symbol



The operator should be obey to the warmings if ignore will be injure anyone



This symbol means when connect the power , do not open this section or will be got electric shock

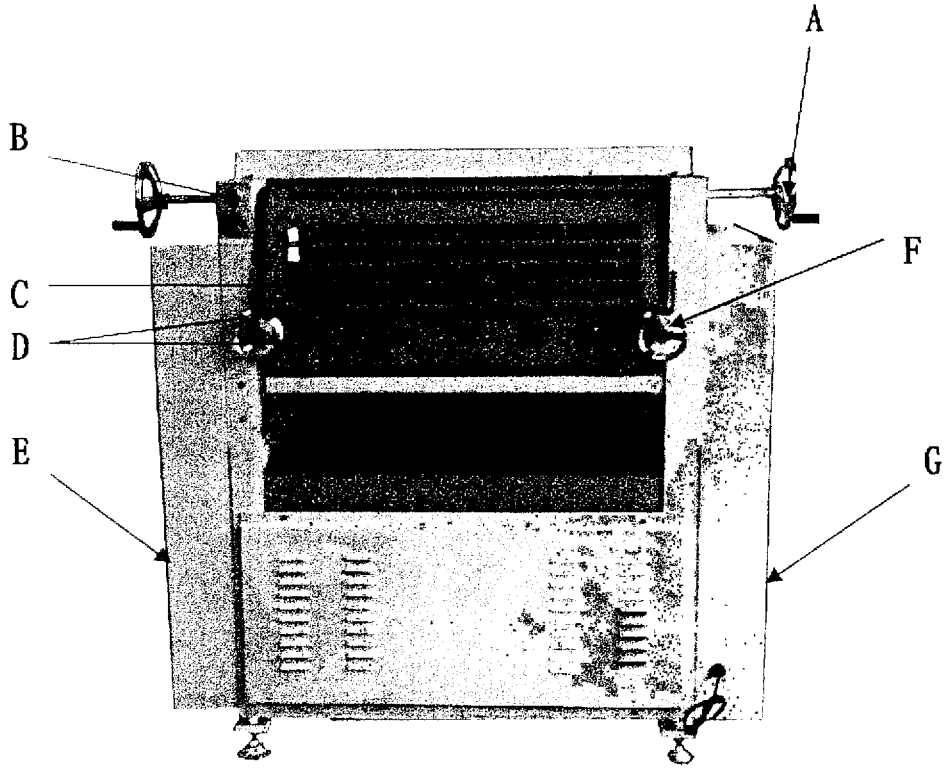
This symbol means when operating , do not put the hand into or it will injure .

IV. Main feature and using of the machine

This machine is mainly use to adhibit Veneer,cabinetwork cord board ,corde board of furniture board and PVC or Double faces timber lamination .It can be use every kinds Gluewater which is no fierceness caustic .It is widely used in the veneer factory ,furniture manufacturer ,Acoustics device factory.

V. Overall and structure of machine

i. Overall of machine



A——Workpiece thickness adjustable wheel

B——Electrical section

C——Gluing section

D——Safety protection section

E——Glue box section

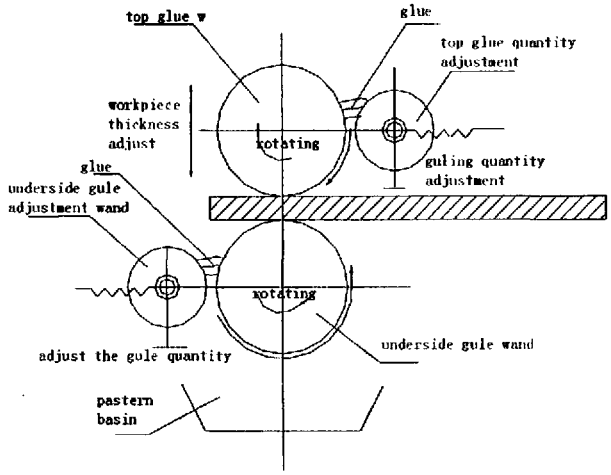
F——Adjustable wheel of glue quantity

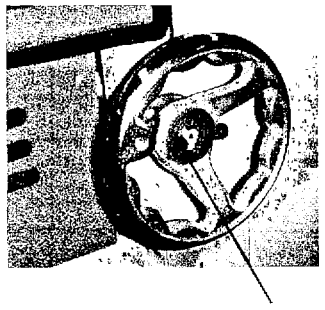
G——Driving section

ii. Main structure of machine

The machine is compose of Gluing section , Workpiece thickness adjustable wheel, Electrical section, Driving section ,Gluing section ,body section and Safety protection section.

A)、 Gluing section



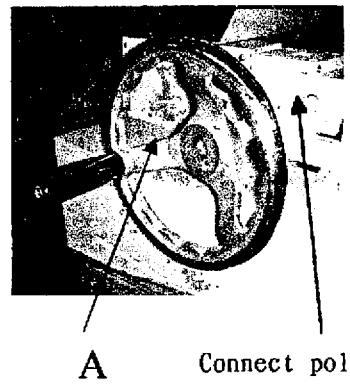


A

It is compose of up and low glue roll,up and low glue quantity adjustable roll ,side board ,glue quantity adjustable device etc .(Just as the photo)The glue roller is made as steel tube processed and with the glue on the surface ;The glue quantity adjustable roller is made with the steel tube which after chromeplate processing .The Quantity roll and adjustable roller is install on the right and left side board .The roller and adjustable roller is install the rotating chain wheel .It is used to finish the power rotating .You can use the right and left hand wheel "A" to adjust the quantity .When clock wise rotating ,the glue quantity adjustable roller close to the roller ,when anticlock wise rotating ,it is leaving .

Note:Before add the gluewater into the roller and adjustable roller ,first should be adjust the opening between roller and adjustable roller .When adjust ,rotating the left adjustable hand wheel till the two roller almost touch each .Then you can add the gluewater into (Note:Before add the gluewater ,forbidden to put the adjustable roller close to the roller to start the machine or it will injury the surface of the roller).

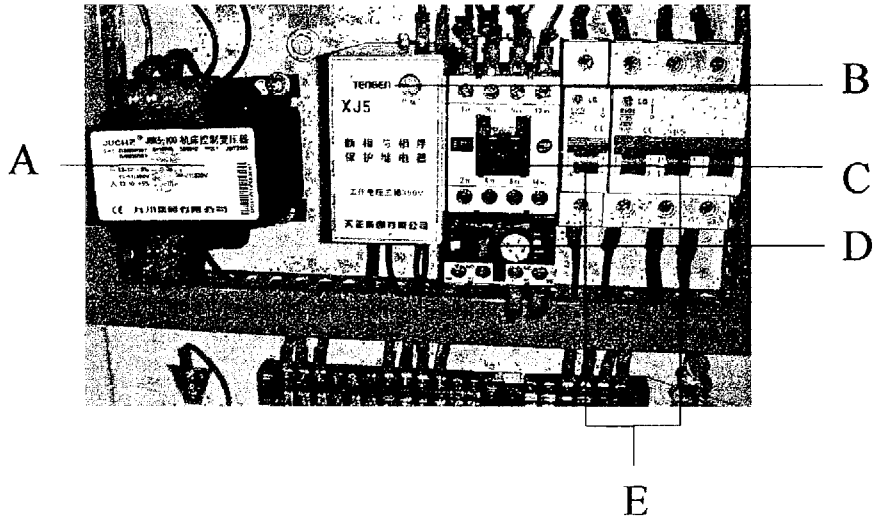
B)、 Workpiec thickness adjustable section : It is compose of the adjustable hand wheel connected pole, pole jointer and right and left worm wheel case etc . Spreading thickness finished by rotating the two sides hand wheel . The function of the worm wheel "A" is to adjust the thickness of gluing workpiece. When clock wise rotating the up roller rising when ; anticlock wise , it will downing .



For example if the workpiece thickness is 10mm,rotating the hand wheel with clock wise ,to make the pointer point 9mm on the staff guage .(note :Avoid to make the rubber on the roller abrasion too early .So the opening between roller can not less then workpeice thickness ,generally about 0.5-2mm is perfect ,When spread the small workpiece ,should be use the length gluing or the roller can not using smooth to abrasion the roller that will cause the roller no even .)

C)、 Electrical control section :It is compose of an AC connector and one Hot relay .and the relay should be protect the 0 and short voltage and voerload protection .and with tow auto recovery button to start and stop control the machine .The reasonable circuit designed and easy operate control panel to operate the machine convenience and easy .

a. Electrical section



A——Control transformer

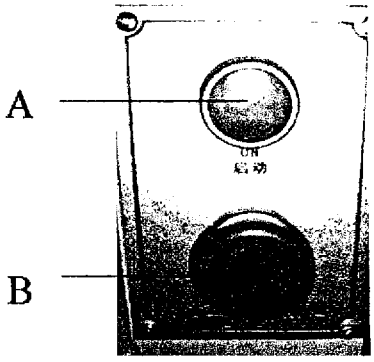
B——break phase and phase sequence protection relay

C——Roller start AC connector

D——Hot relay :To protect the motor

E——Breaker ;To protect the short circuit

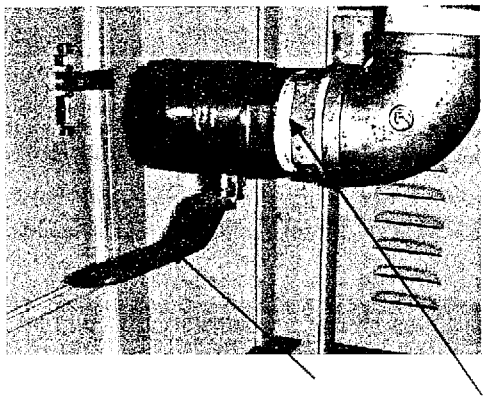
b. Controll panel



A——Start button :Press this button to start the machine

B——Stop button :Press this button to stop the machine

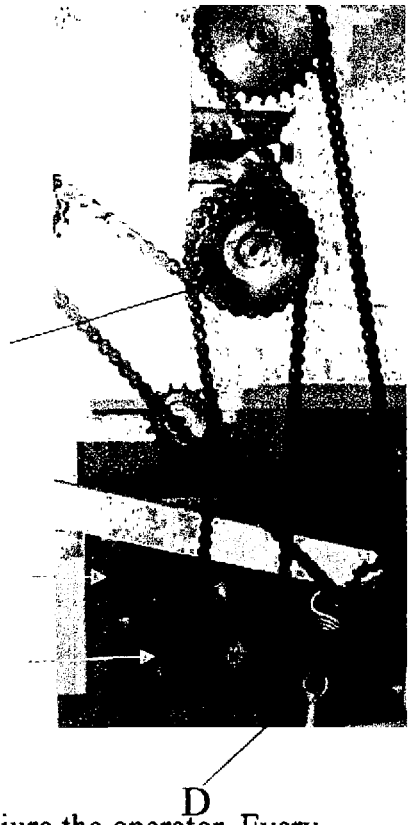
D)、 Glue tray section and drain: The glue tray is made of the steel ,there is drain switch under the tray .Every time finish gluing and clean ,you can press the switch to let the sewage out .



Step of drain:

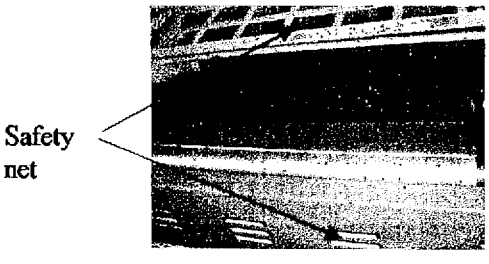
①、Cleaner ②、Open the drain case on "A" ③、Press the switch "B" to let the sewage to the tray. ④、After finish drain close the switch "B" then close the door.

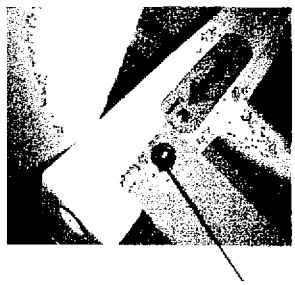
E)、 Driving section :It is compose of motor "A" Reducer "B" elastic tighten chain "C" .Motor is 100L-4 2.2KWInstalled way :B3 ,Reducer is WD80I .The rate is 1:30,the power is give out by motor ,drive the chain to up and low roller and up and low adjustable roller by reducer ,to finish gluir working .Spring "D" is to auto adjust gear driving .

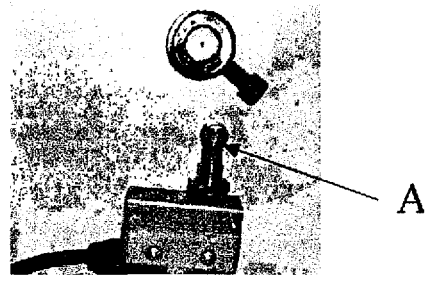


F)、 Body section :It is compose of steel and steel board .The structure is simple ar goodlook .

G)、 Safety protection section :There is install tl safety protection net to avoid the hand touch the roller moving section when the machine is working ,avoid to injure the operator .Every time before operate the machine should be check the protection net normal or not .If there are any broken ,should be adjust or replace in time .The following picture "A" is travel switch .When operating the machine ,the operate should be open the safety protection carefully ,Cover jointer pole rotating touch the travel switch then cut off the AC connector on the roller start to make the roller stop immediately to protect.







VI. Main technology parameter of machine

Parameter / Preduct Type / Parameter name	MH6206	MH6106	MH6113	MH6213
Max gluing workpiece width	630mm	630mm	1300mm	1300mm
Max gluing workpiece thickness	80mm	80mm	80mm	80mm
Feeding speed	17m/min	17m/min	17m/min	17m/min
Gluing speed	33r/min	33r/min	33r/min	33r/min
Rate power	2.2kw	2.2kw	2.2kw	2.2kw
Rate of out put	1:30	1:30	1:30	1:30
Overall dimension	1550x900x1400mm	1550x900x1400mm	2350x900x1400mm	2350x900x1400mm
Machine weight	750kg	680kg	800kg	950kg

VII. Loading and transport of machine

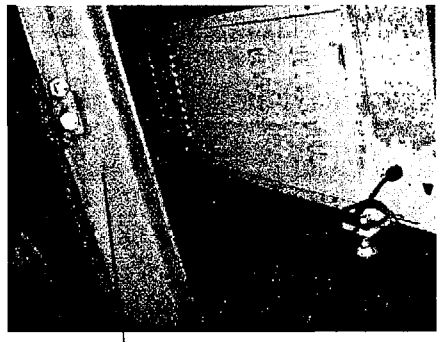
This machine is the whole set structure .When transporting must be fixed all the shockproof ,dampproof ,defend strike etc measures .When the user loading should be required the professional person to carry out .

i. Transport and stock environment requirement :Transport and stock should be during -25℃-55℃ .If Under more than 55℃ but less than 70 ℃ environment , the machine can not working over 24 hours

ii. Loading

a). When loading the machine should be evacuate people and set the safety protection

b). Use the crane or electrical forklift which weight enough to loading the machine .During the whole loading procedure should be make sure the machine is steady ,when the machine lifting ,forbidden around anyone (The right picture is the forklift loading)



Forked vehicle

c). After loading put away all the safety device loading tool and temporary device

VIII. Install debug and operation of machine

i. Install debug

A). Environment required of install the machine

The requirement environment of install machine :1.Install dimension :

①.4000x4000x4000mm ② temperature :-10°C-55°C ③.Atmosphere humidity :85%

④.Height above sea level:hereinafter1000M

B). Lay out of machine

The machine should be lay out on the flat concrete .After lay out the machine ,adjust the level of the machine to make sure the front ,back ,right and left four point on the same height

C). Distribution

According the distribution of the required ,connect into the voltage ,current and frequency on the power terminal

ii. Operation

A). Safety check before operate the machine

Before operate the machine ,first check the machine carefully to make sure safety

①、Check every safety device correct ,firmly or not .

②、Check every rotating and connecting section firm or not

③、After carry out the safety protection switch ,check every motor rotating section agility ,smooth or not .

④、After finish above working point start the "Start button " check every rotating section correct or not ,The direction is Face to the machine the up chromeplate roller (that is up glue quantity adjustable roller) rotating direction is clock wise ,the up roller direction is anti clock wise .If you find any un correct direction ,that you can exchange any two wire of the three phase wires .

B). Operation

①、Adjust the required workpiece thickness by the right and left side worm wheel

②、Adjust the required glue quantity by front and back worm .The right and left wheel linkage till quantity of right and left is even .

③、After make sure the above processing ,that you can start working ,press the "Start button" to start the machine .Then you can start working .

④、After finish working ,press the red stop button to make the machine stop .

C). working after operated

After the machine stop ,anti clock wise to rotating the adjustable hand wheel to enlarge the clearance between roller and glue quantity adjustable roller then use the long handle brush to rinse till it clean then drain out the sewage .

IV. Failure and solution

Failure	Reason	Solution
Press the operation button but can not operate	Close the general power and control power	Open the power switch
	The breaker does not close	Open the electrical case and close the breaker
	The connector does not work or hot relay broken	Check the circuit whether broken or overload and repair
	Does not cover the safety protecton	Cover it
The machine sudden stop when it is working	Short circuit or breaker tread	Check the motor isolation qualify or not ,the machine whether install the earth wire and close the breaker

V. Maintenance of machine

i. Daily maintain

A). Keep the machine clean ,and keep every driving section and connection lubricant

B). Forbidden to put anything on the machine

C). After every gluing working clean the machine must be drain out the sewage

ii. Weekly checking of machine

A). Every time before working ,should be check every moving and safety device correct or not and operate the machine one time and check the moving correct agility and firmly or not .

B). Every moth should be do a carefully checking , especially for checking the up and low roller abrasion condition and every safety protection fitting condition and adjust and replace .

C). For the moving section,every shift should be add the lubricant oil .If operation

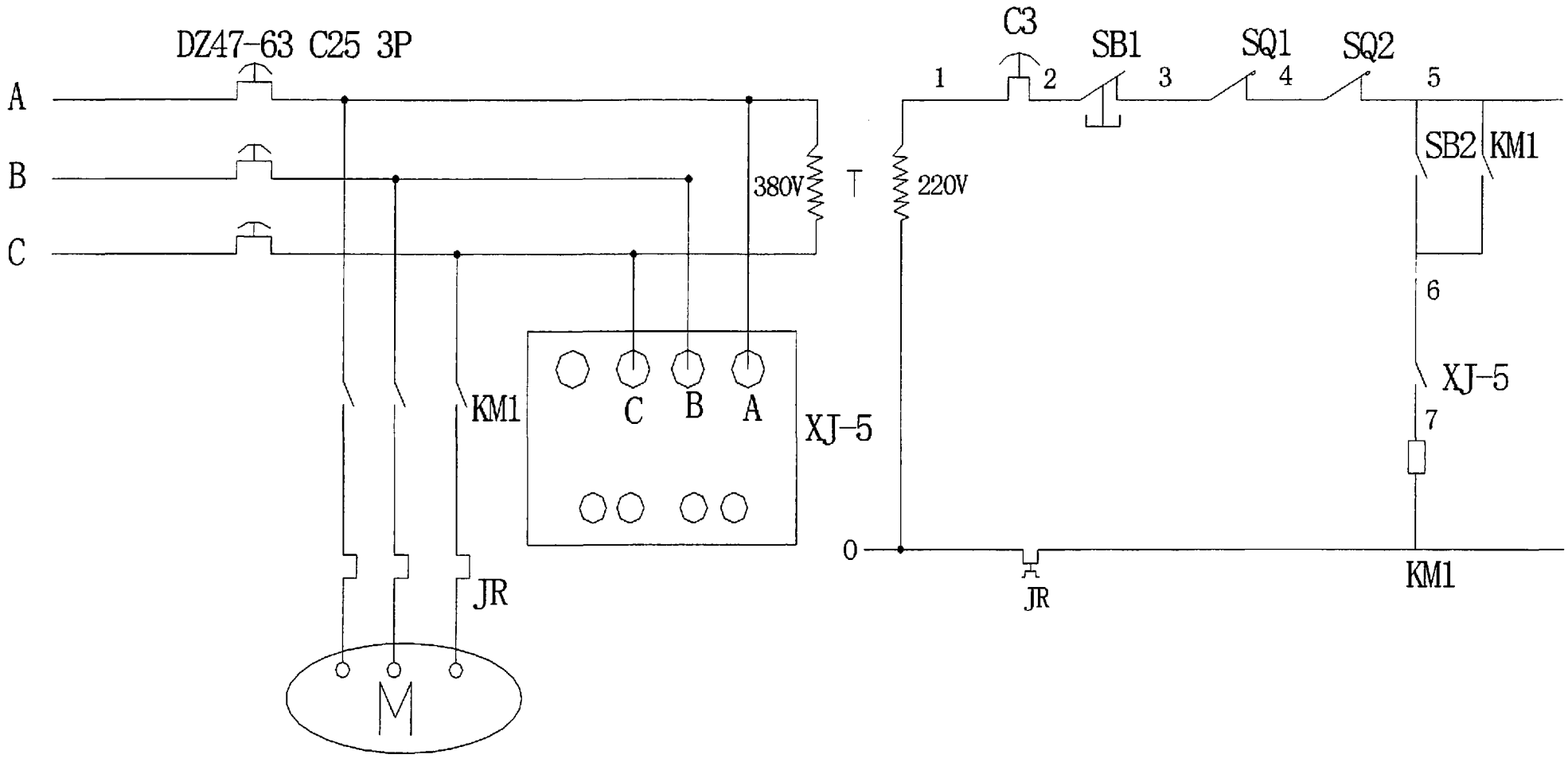
the machine for a long time there are any abnormity sound should be stop checking and maintain and replace the fittings .

iii. Maintain when stock the machne

A). If the machine does not operating should be clean the machine and add lubricant oil on every driving section and packing well .

B). Should be put the machine inside the ventilative , dryness room avoid the sun shine and rain directly

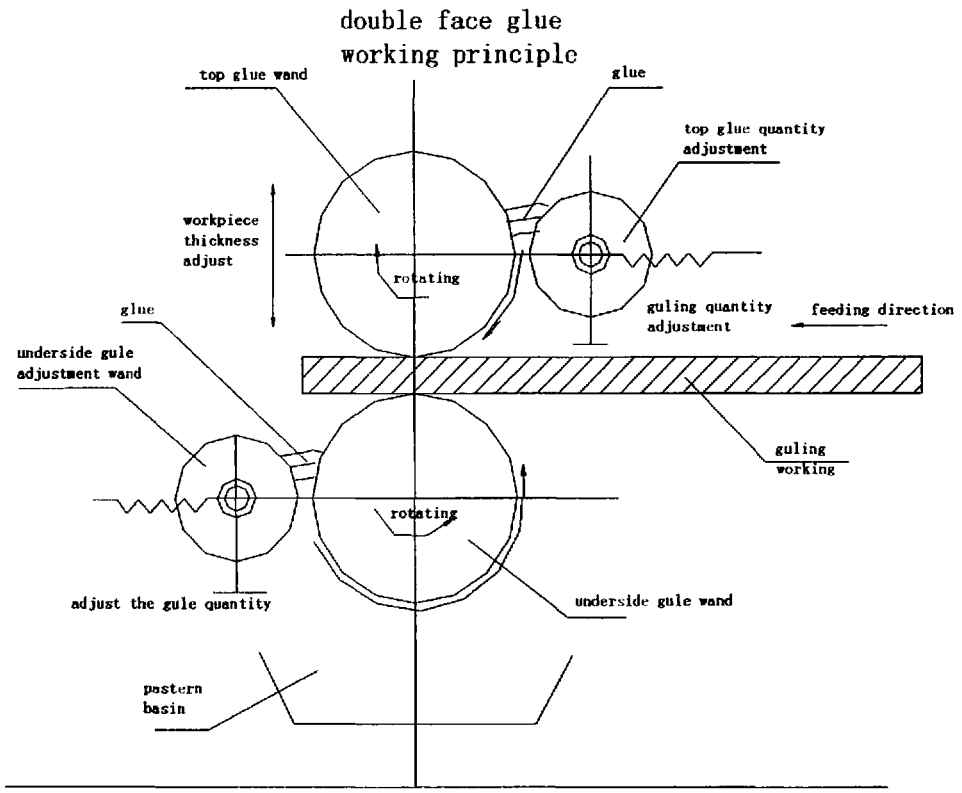
VI. Electrical principle diagram

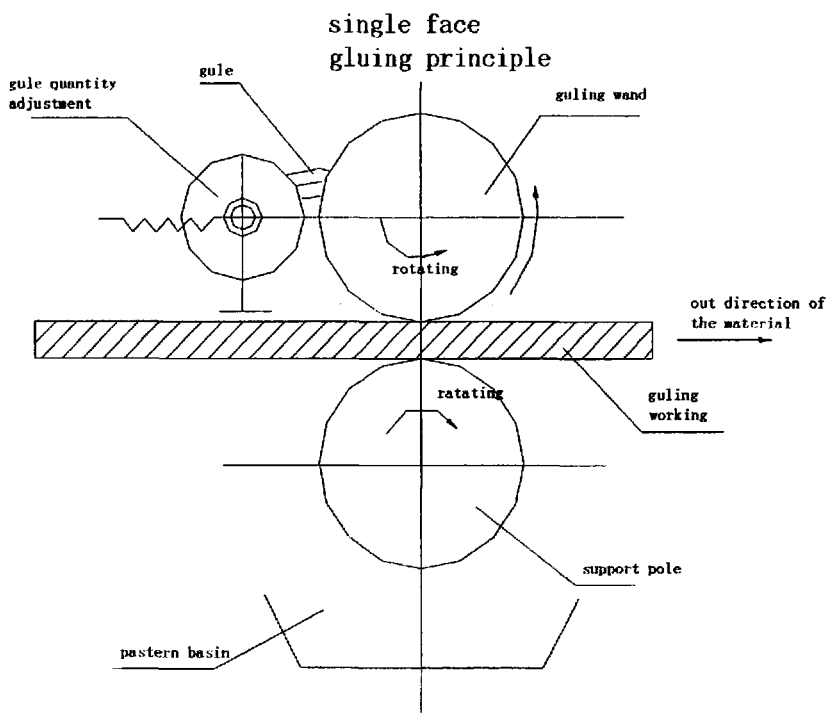


VII. Electrical fittings detail list

No.	Description	Moel	Q.ty	Note
1	Line Row	TD1512	1 pc	
2	Control transformer	JBK5-100 (36)	1 pc	
3	Air switch	BKN C25 3P	1 pc	
4	Air switch	BKN C3 1P	1 pc	
5	Connector	XSC1-011 (36V)	1 pc	
6	Hot relay	XSR1-012	1 pc	
7	Break phase protection	XJ-5 (36V)	1 pc	
8	Travel switch	TZ7311	2pcs	
9	Start button	LA38-01	1pc	
10	Emergency stop button	LA38-10	1pc	

VIII. Gluing working principle





IX. Fittings detail of machine

No.	Description	Q. ty	Note
1	Lifting bearing of big roller	4	
2	Big roller	2	
3	Light roller	2	
4	Worm wheel case bearing	2	
5	Big roller bearing cover	8	
6	Bit nut	8	
7	Little nut	2	
8	I Light roller bearing room	2	
9	Light roller bearing cover	4	
10	II Light roller bearing room	2	
11	Worm wheel case	2	
12	Worm wheel	2	
13	Worm pole	2	
14	Adjustable screw	2	
15	Left of copper baffle	2	
16	Right of copper baffle	2	
17	Light roller valve	4	
18	Big valve	4	
19	Long screw	1	
20	Core of chain wheel	3	
21	Big chain wheel	3	
22	Chain wheel	2	

No.	Description	Q. ty	Note
23	Double chain wheel	1	
24	Driving big gear wheel	2	
25	Driving small gear wheel	2	
26	Driving small gear wheel	4	
27	Gear connected board	2	
28	Gear connect arm	2	
29	stainless steel tray	1	
30	Model A belt	1	
31	Big belt	1	
32	pull spring	1	
33	Deep channel ball bearing	30	
34	Push channel ball bearing	4	
35	Big hand wheel	2	
36	Small hand wheel	4	

Packing List

DOUBLE FACE GLUE SPREADER MACHINE

NO.	Name	Quantity	Remark
1	Mainframe	1set	Weight: 750kg
2	Cross spanner、	Apiece 1 pcs	In tool case
3	Specialize spanner	1pcs	In tool case
4	Draw board	1pcs	In tool case
5	10 Hexangular key	1pcs	In tool case
6	25 Hexangular key	1pcs	In tool case
7	User Manual	1 copy	
8	User Manual	1 copy	
9	Packing list	1 copy	

Inspector for packing: (seal) TEST 2 Date: